



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2151
Job Sheet 185890



Part No: D2151

Job Qty: 12 ea

Part Name: Packer Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/6/18

Job Tracking No:

Due Date: 11/27/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP C 00.10.23 Re-format (mpp 2101) EC IPP Rev:D 06-04-28 Manufactured on Water Jet JLM
IPP Rev:E 06-11-24 As per Rev B JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		11/27/18	0.00	0.41	Waterjet - Flow		SE 18/11/18
120	QC	12 pcs		11/27/18	0.00	0.00	QC8		38
130	Small Fab	12 pcs		11/27/18	0.00	0.00	Small Fab 1	1014	9-89
140	HandFinish	12 pcs		11/27/18	0.00	0.18	HandFinish1		DR 18/11/19
150	Powdercoat	12 pcs		11/27/18	0.00	0.11	Powdercoat1		DR 18/11/19
160	QC	12 pcs		11/27/18	0.00	0.00	QC3		38
170	Packaging	12 pcs		11/27/18	0.00	0.00	Packaging3-1	ST 602	NOV 22 2018
180	QC21-SA	12 Ea		11/27/18	0.00	0.00	QC21		21

Part Op 100 - 1-Cut as per Dwg D2151

Descriptions: 130 - Deburr

150 - START TIME: 8:30 FINISH TIME: 9:00 O.V.T. 320 M138951.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	.4200 sf (.035 ea)	100-Waterjet - Flow - 1	5114846

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.040	0	85	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Packer	0.098Inches + 0.005 - 0.000	0.103 0.098	0.098 Diameter	
2	Packer	0.171Inches + 0.005 - 0.000	0.176 0.171	0.172 Diameter	
3	Packer	0.231Inches ± 0.010	0.241 0.221	0.230	
4	Packer	1.217Inches ± 0.010	1.227 1.207	1.213	
5	Packer	2.194Inches ± 0.010	2.204	2.196	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																													
Date : _____		Step #: _____		Description Work Order Deviation Container No: S126942 Part: D2151 Job No: 185890 Serial No/Batch: S126942 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 11/12/18																																																																																																																													
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			2.184	
6	Packer	2.300Inches ± 0.010	2.310 2.290	2,295
7	Packer	1.560Inches ± 0.010	1.570 1.550	1,558
8	Packer	0.250Inches ± 0.010	0.260 0.240	0,250
9	Packer	1.328Inches ± 0.010	1.338 1.318	1,325
10	Packer	0.342Inches ± 0.010	0.352 0.332	0,340
11	Packer	0.740Inches ± 0.010	0.750 0.730	0,740
12	Packer	2.050Inches ± 0.010	2.060 2.040	2,049
13	Packer	0.040Inches ± 0.010	0.050 0.030	0,040

Plex 11/6/18 11:28 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
			Completed By																		
			Lead hand / Supervisor Approval Verification																		
			QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																
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